

Work Order ID 101394

May-09-13 1:47:56 PM

101394

Page 1

Item ID: D4617-041

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Item Name: Emergency Escape Ladder

Stop ***NS2***

Start Date: 5/09/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/23/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 1305-09

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4617	B

100 0.00

100

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

BEND RAIL AS PER DWG AND TO FIT PROFIL OF WELDING JIG DT9803
(ON LENGTH OF TUBE, 20 FEET MAKES 2 RAILL)

1 EL 14-4-22

110

Weld per dwg A/R 4130 rod Batch: 1127925 0.00

110

Large Fab

Memo

0.00

Large Fab

1- CUT STEPS AS PER DWG AND PREP FOR WELDING

2- CUT RAIL

3- INSTALL PARTS ON WELDING JIG DT9803 AND WELD AS PER DWG

1 EL 14-4-22

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

①

14-04-22

DAS
9
9-00

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

①

14-04-22

DAS
9
9-00

140

Pressure Wash per QSI005 4.3

0.00

140

HandFinish

Memo

0.00

Hand Finishing

1

14-04-22

Work Order ID 101394

May-09-13 1:47:56 PM

101394

Page 6

Item ID: D4617-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Emergency Escape Ladder

Start Date: 5/09/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/23/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 <i>M 113645</i> Memo START TIME: <i>11:30</i> OVEN TEMPERATURE: <i>500</i> FINISH TIME: <i>0:00</i>	0.00 0.00				<i>1</i>	<i>0</i>	<i>14-4-22</i>	<i>338</i>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>1</i>			<i>14/02/23</i>
170 *170* Small Fab Small Fab	 Memo 1- Assemble clamps, clamps cover and tube caps to ladder as per dwg 2- Install decals as per dwg	0.00 0.00				<i>1</i>			<i>FF</i> <i>14-04-24</i>

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Setup Start

NS1

Revision ID:

Item Name: Emergency Escape Ladder

Stop

NS2

Start Date: 5/09/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/23/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Identify as per dwg & Stock Location:	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

68-6
32
DAS

14/4/24

14/04/24

14-4-24

Picklist Print

May-09-13 1:48:01 PM

Page 1

Work Order ID: 101394

101394

Parent Item: D4617-041

D4617-041

Parent Item Name: Emergency Escape Ladder

Start Date: 5/09/13

Required Date: 5/23/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.04.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M4130NT0.750W.035
Purchased
No
100 f
286.4900 20 21.05263
**
Q 14-4-22

M4130NT0 750W 035
4130 RD TUBE .750 X .035W

Location	Loc Qty	Loc Code
MAT032	70.49	
121250	70.49	
MAT033	216	
21910	216	

M4130NT0.750W.035
Purchased
No
110 f
286.4900 5.06 5.326316
**
EL 14-4-22

M4130NT0 750W 035
4130 RD TUBE .750 X .035W

Location	Loc Qty	Loc Code
MAT032	70.49	
121250	70.49	
MAT033	216	
121910	216	

D4617-045
Manufactured
No
170 Each
4.0000 4 4
**
FF 14-04-24

D4617-045
Clamp Assembly

Location	Loc Qty	Loc Code
ST115	4	
85918	4	

2
2

Picklist Print

May-09-13 1:48:01 PM

Page 2

Work Order ID: 101394

Parent Item: D4617-041

Parent Item Name: Emergency Escape Ladder

101394

D4617-041

Start Date: 5/09/13

Required Date: 5/23/13

Start Qty: 1.00

Required Qty: 1.00

D4618-041

Manufactured No

170

Each

14.0000

4

4

D4618-041

Clamp Assembly Cover

**

FF 14-04-24

Location

Loc Qty

Loc Code

ST187

14

83121

2

84410

12

D4621-1

Manufactured No

170

Each

14.0000

2

2

D4621-1

Decal

**

FF 14-04-24

Location

Loc Qty

Loc Code

ST115

14

83682

6

95979

8

D4621-3

Manufactured No

170

Each

24.0000

1

1

D4621-3

Decal

**

FF 14-04-24

Location

Loc Qty

Loc Code

ST115

24

83683

21

95580

3

D4625-1

Manufactured No

170

Each

85.0000

4

4

D4625-1

Tube Cap

**

FF 14-04-24

Location

Loc Qty

Loc Code

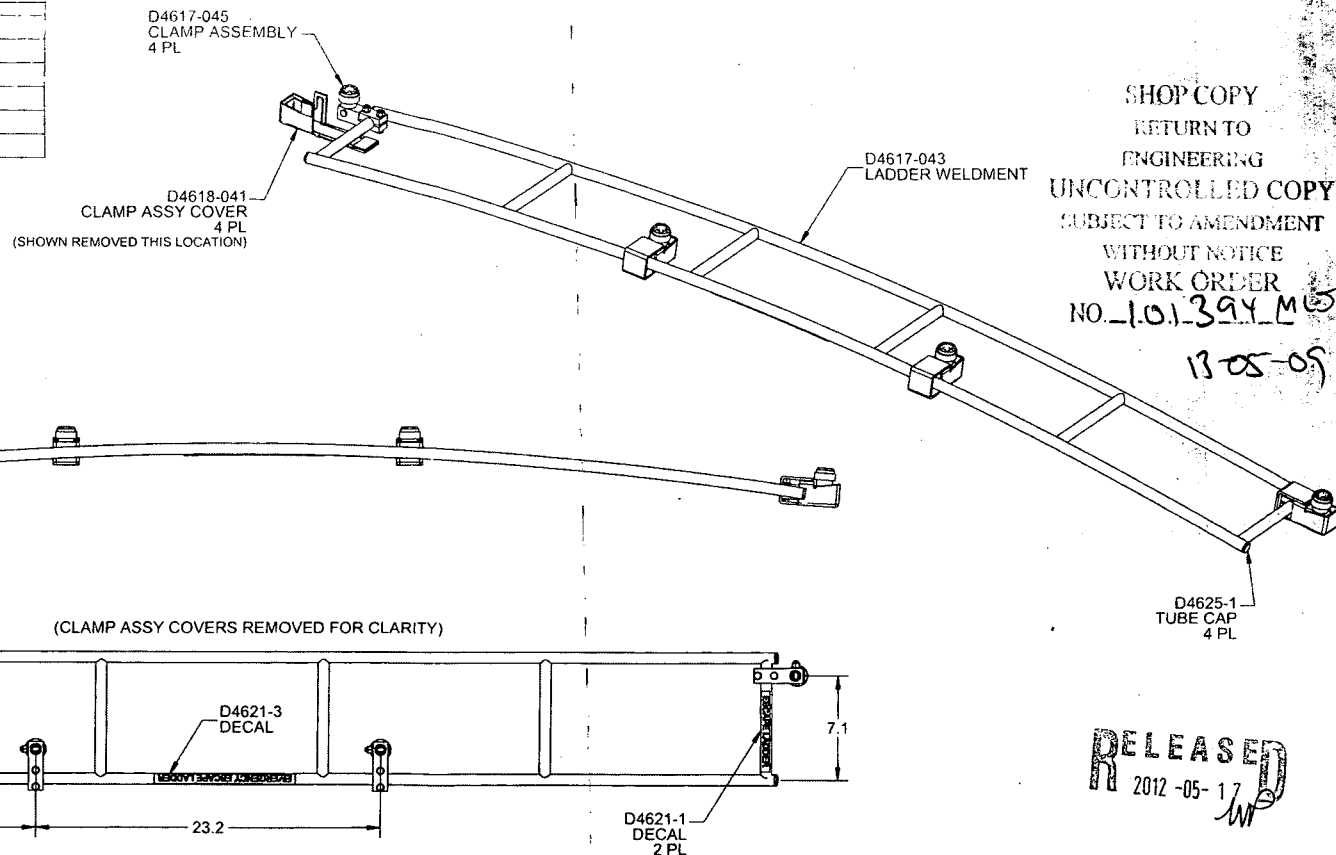
ST115

85

83122

85

ITEM	QTY	P/N	DESCRIPTION
	041		
	X	D4617-041	EMERGENCY ESCAPE LADDER
1	1	D4617-043	LADDER WELDMENT
2	4	D4617-045	CLAMP ASSY
3	4	D4618-041	CLAMP ASSY COVER
4	2	D4621-1	DECAL
5	1	D4621-3	DECAL
6	4	D4625-1	TUBE CAP



D4617-041 EMERGENCY ESCAPE LADDER

NOTES:

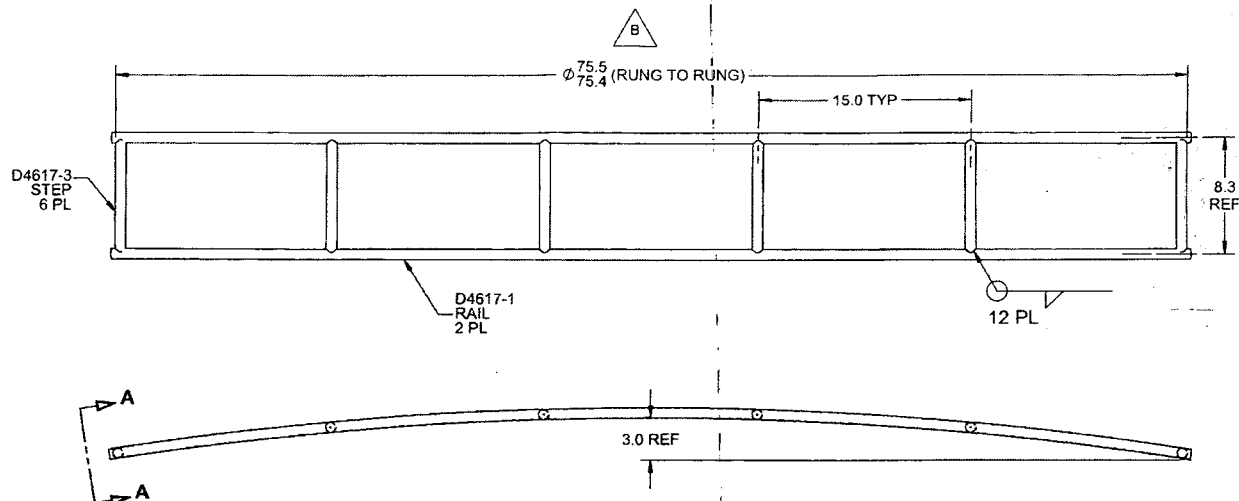
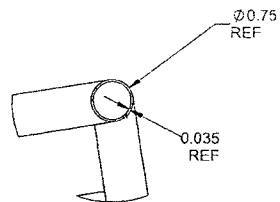
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4617-041" AND BATCH NUMBER PER QSI044 6.6
- 7) WEIGHT: 6.48-lbs

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 101394 M5
1305-09

RELEASED
2012-05-17

B	75.4-75.5 WAS 75.7 (C4-2) WASHER WAS NAS1149C0463R, QTY 3 ON SHT 4. 0.753-0.756 WAS 0.750-0.753 (B4-5)	RP	12.05.01
A	NEW ISSUE	RP	12.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4617	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		EMERGENCY ESCAPE LADDER	INTS
DATE	12.05.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

101394



D4617-043 LADDER WELDMENT

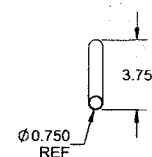
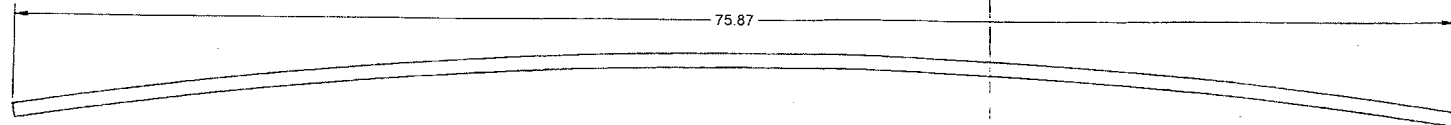
RELEASED
2012-05-17

NOTES:

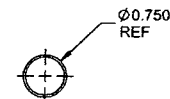
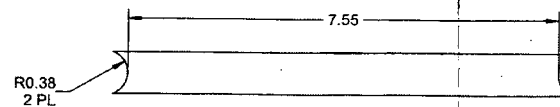
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: 4.5 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	RP	DRAWING NO. D4617	REV. B
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE EMERGENCY ESCAPE LADDER	SCALE NTS
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DATE	12.05.01		

1011394



D4617-1 RAIL



D4617-3 STEP

RELEASED
2012-05-17

NOTES:

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T6736
OR AMS6371, 6360, 6361, 6362, 6373, 6374
REF DART SPEC M4130NT0.750W.035
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER DART QSI044 6.6
- 7) WEIGHT: D4617-1 1.7lbs
D4617-3 0.17lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4617	SHEET 3 OF 5
APPROVED		TITLE	SCALE
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